

opened, "Eval EP-G" sold by Kuraray Inc. was fed into the subsidiary extrusion flow passage at an extrusion temperature of 200° to 220° C. under a feed pressure of 120 to 250 kg/cm². The resin composite extruded from the main extrusion opening was cooled, cut and examined. It had the vertical sectional shape shown in FIGS. 4 and 5, but roping of the subsidiary resin remained.

COMPARATIVE EXAMPLE 2

Comparative Example 1 was repeated except that the time of closing the subsidiary extrusion opening was prolonged to about 30 seconds. The extruded resin composite was cooled, cut and examined. Roping of the subsidiary resin remained.

We claim:

1. Apparatus for extruding multiple synthetic resins, comprising;

a main extrusion flow passage having a main extrusion opening,

means for providing a continuous flow of a main resin to said main extrusion flow passage;

a subsidiary extrusion flow passage having a subsidiary extrusion opening, at least a downstream portion of the subsidiary extrusion flow passage being disposed in the main extrusion flow passage;

means for providing an intermittent flow of subsidiary resin from said subsidiary extrusion flow passage;

an auxiliary extrusion flow passage having an auxiliary extrusion opening, said auxiliary extrusion flow passage having a downstream portion which extends through the main extrusion flow passage where the main extrusion flow passage surrounds the downstream portion of the subsidiary extrusion flow passage, said auxiliary extrusion opening

being positioned downstream of the subsidiary extrusion opening;

means for providing a continuous flow of auxiliary resin to said auxiliary extrusion flow passage;

said means for providing an intermittent flow of subsidiary resin including an opening-closing member for opening and closing the subsidiary extrusion opening during said continuous flow of main resin and auxiliary resin to provide said intermittent flow of subsidiary resin from said subsidiary extrusion flow passage, said opening-closing member having a forward end portion; and,

means for moving said opening-closing member to a stationary position where it closes the subsidiary extrusion opening and the forward end portion thereof lies in the path of the auxiliary resin so that the auxiliary resin collides with said forward end portion to prevent the formation of a thread-like portion of the subsidiary resin in the main resin when the subsidiary extrusion opening is closed.

2. Apparatus according to claim 1 wherein the forward end portion of the opening-closing member is of tapered shape, said opening-closing member being movable to a position where its forward end portion projects downstream of the subsidiary extrusion opening.

3. Apparatus according to claim 1 wherein the cross-sectional area of the auxiliary extrusion opening is substantially equal to that of the subsidiary extrusion opening.

4. Apparatus according to claim 3 wherein the forward end portion of the opening closing member is of tapered shape, said opening-closing member being movable to a position where its forward end portion projects downstream of the subsidiary extrusion opening.

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